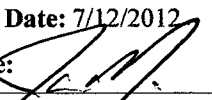


Work Order ID 87021***87021***

Page 1

Monday, July 09, 2012 8:57:01 PM

Item ID: D4522-25 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Latch Shaft
Start Date: 7/10/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 7/12/2012 Req'd Qty: 2.00 *2* Customer:
Reference: 

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4522	B								

100		0.00				2	0		
-----	--	------	--	--	--	---	---	--	--

100

Doosan

Doosan Lathe

Memo

MILL AS PER DWG AND FOLIO FB124

DWG REV: 2FOLIO REV: 12/1

DEBURR

.0.00

DAS
13
0-03

12/7/13

120	QC2- Inspect parts off machine FAI/FAIB	0.00				2	0		
-----	---	------	--	--	--	---	---	--	--

120

QC

Quality Control

Memo

.0.00

DAS
13
0-03

12/7/13

Work Order ID 87021***87021***

Page 2

Monday, July 09, 2012 8:57:01 PM

Item ID: D4522-25 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Latch Shaft
Start Date: 7/10/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 7/12/2012 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
14
2-89

12/07/16

2

2

160

Identify as per dwg & Stock Location: **117**

0.00

160

Packaging

Memo

0.00

Packaging

2x

Sp
12-7-16

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/7/18

inf
12-07-16

Picklist Print

Monday, July 09, 2012 8:57:00 PM

Page 1

Work Order ID: 87021

Parent Item: D4522-25

Parent Item Name: Latch Shaft

Start Date: 7/10/2012

Required Date: 7/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-12-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 303 Round Bar 0.500"		Purchased	No				f	261.7260		0.5684211			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	261.726	
117143	11.34	
118509	1.36	
119009	137.705	
119616	36.737	
121728	74.584	

*for 12-07-17 Batch
this 303 .375 only*

~~11578~~
115868

6 ft

DAS
13
0-0

8 7 6 5 4 3 2 1

D

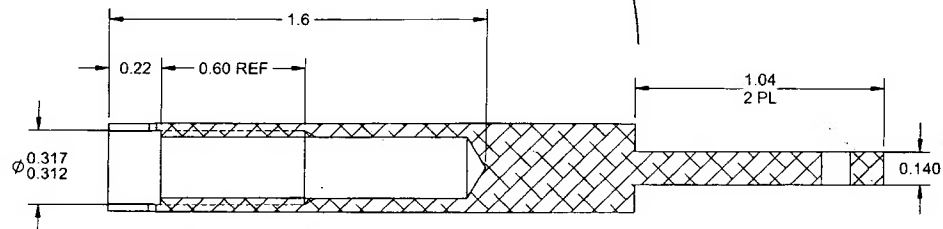
C

B

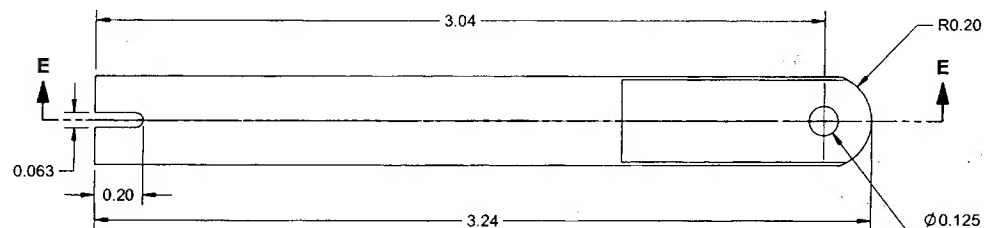
A

5/16-18 UNC-2B
0.60 DP

Ø 0.375
Ø 0.370



SECTION E-E



D4522-25 LATCH SHAFT

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART-QSI-044 6.6 OR 6.7
- 7) WEIGHT: N/A

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	RP	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 20 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2012-06-13

8 7 6 5 4 3 2 1

03125

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 87021
Description: Latch Shaft		Part Number: A7522-25
Inspection Dwg: A7522 Rev: 15		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.320-.375	N/A	.375	/		SA-7	Vel
Ø.312-.317	N/A	.3125	/			
.22	±.030	.22	/			
.60 ref	±.030	.60	/			
1.6	±.100	1.6	/			
1.04	±.030	1.04	/			
.140	±.010	.141	/			
3.04	±.030	3.04	/			
3.24	±.030	3.245	/			
.20	±.030	.190	/			
.063	±.010	.060	/			
Ø.125	±.005/-001	.125	/			
R.20	±.030	R.20	/		RG	
5/16-18 UNC 2B	N/A	5/16	/			

Measured by: DAS 13	Audited by: DAS 14	Preliminary Approval:
Date: 12/7/13	Date: 12/17/16	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15